

# Work Order ID 77871

**\*77871\***

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December-22-11 10:07:09 AM

Item ID: D350-589-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Side Door Latch Modification

Start Date: 22/12/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/12/22

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

SPC (Y/N): \_\_\_\_\_

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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INN-D350-589	E
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100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

*S 12/01/05*

*OK Per MLJ 12/01/04*

105

0.00

**\*105\***

Pick Kit

Packaging

Memo

0.00

Packaging

*12/01/04 (4)*

110

0.00

**\*110\***

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*S 12/01/05*

*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D350-589-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Side Door Latch Modification

Start Date: 22/12/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

**\*120\***

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per QSI 014

0.00

0.00

130

**\*130\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

17/1/3 40

CK 12/01/06

M.L.J 12/01/05  
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 77871

\*77871\*

Parent Item: D350-589-011

\*D350-589-011\*

Parent Item Name: Side Door Latch Modification

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29Removed D2587 PlugKJ  
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
<i>Sy</i> *AN960.ID10*									**	119537			
Washer													
D2237		Manufactured	No			105	Each	2.0000	3	12			
<i>Sy</i> *D2237*									**	77872			
Striker Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		2							
				66139		2							
D2583		Manufactured	No			105	Each	21.0000	3	12			
<i>Sy</i> *D2583*									**				
Latch Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		21							
				76074		21				76074			
D2585		Manufactured	No			105	Each	29.0000	3	12			
<i>Sy</i> *D2585*									**				
Mounting Channel													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		29							
				73297		2							
				74488		27				79488			

12/21/11 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 77871

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Parent Item: D350-589-011

\*D350-589-011\*

Parent Item Name: Side Door Latch Modification

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2586 Manufactured No

105 Each

31.0000

3

12

\*D2586\*

Door Latch

\*\*

Location

Loc Qty

Loc Code

ST204

31

74489

31

105 Each

16.0000

1

4

D2587 Manufactured No

\*D2587\*

Door Slug, 350 Hinge

\*\*

Location

Loc Qty

Loc Code

ST017

16

74522

16

105 Each

40.0000

1

4

D2589 Manufactured No

\*D2589\*

Keys, Key Chain, 350 Hinge

\*\*

Location

Loc Qty

Loc Code

ST018

40

58194

40

105 Each

1,738.000

6

24

MS20470AD4-5 Purchased No

\*MS20470AD4-5\*

Rivet, Universal Head

\*\*

Location

Loc Qty

Loc Code

ST319

1738

118405

1738

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-589-011

\*D350-589-011\*

Parent Item Name: Side Door Latch Modification

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

105

Each

6,840.000

3

12

\*MS21042L3\*

\*\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

6840

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

796

MS27039-1-15

Purchased

No

105

Each

133.0000

3

12

\*MS27039-1-15\*

\*\*

Screw

## Location

## Loc Qty

## Loc Code

ST291

133

118093

22

118574

11

119736

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

5

## 52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.